

Date: Tuesday, 5/1/2007 3:17:39 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 32129	
Estimate Number : 12840	
P.O. Number : <u>N/A</u>	Part Number : D35421
This Issue : 5/1/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3542 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : <u>N/A</u>	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 5/13/2007 Qty: 20 Um: Each
Checked & Approved By : <u>[Signature] 07.05.01</u>	
Comment : Est Rev:A New Issue 07-04-23 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B3000X01500	6061-T6 Bar 3" x 1.5"
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Comment: Qty.: 0.3500 f(s)/Unit Total : 6.9993 f(s)
 6061-T6 Bar 3" x 1.5" 4" long
 BATCH: M16536

Jml 07/05/09 20

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA684 Rev: AA & Dwg D3542 Rev: A

2-Deburr per dwg D3443

Jml 07/05/09 20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Jml 07/05/09 20

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Jml 07.05.09 20

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-J 07/05/10 20X

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: (D) Date: 07/05/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M103706



20X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*****ENSURE TO MASK INSIDE BORE*****

M-L 07/05/11

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7/5/14 sep



20

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SF 116

7/5/14 sep

20

9.0

QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

7/5/14

Job Completion



U 07-05-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

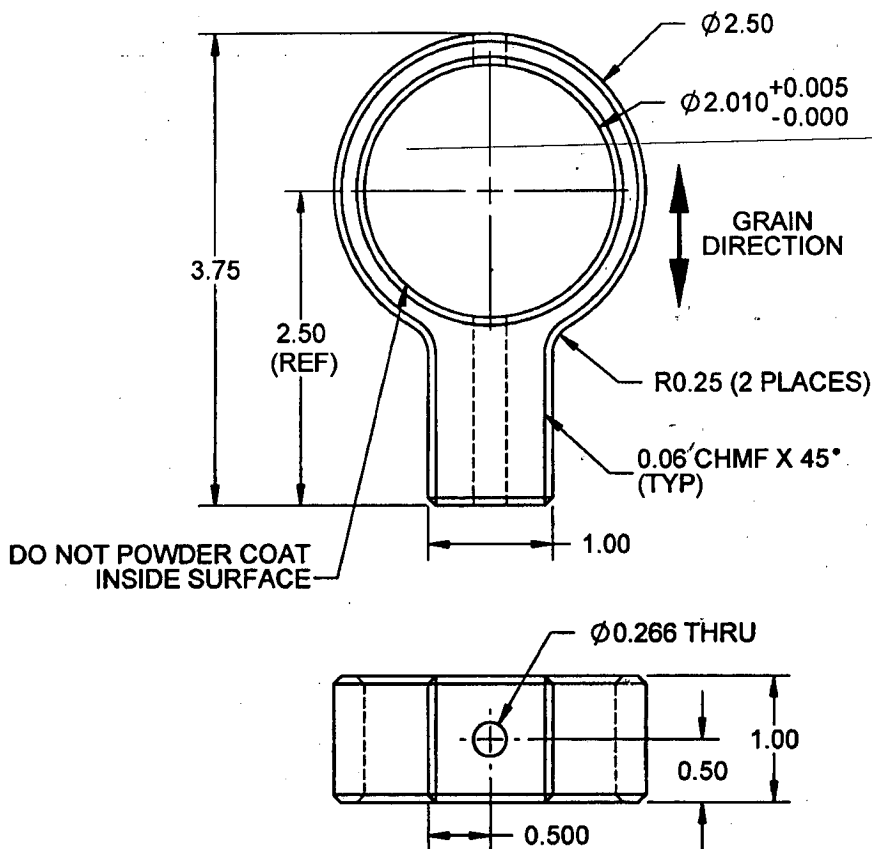
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



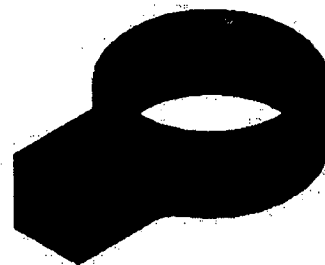
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>A</i>	DRAWING NO. D3542	REV. A SHEET 1 OF 1
DATE 06.11.27		TITLE BRACKET	SCALE 2:3
REV A	DATE 06.11.27	DESCRIPTION NEW ISSUE	

RELEASED
07.04.02



D3542-1 BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32129



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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